

Work Order ID 110017

December-17-13 9:06:14 AM

110017

Page 1

Item ID: D412-698-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Door Handle -Aluminum Door

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-17-13

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN D412-698

Rev E

100

0.00

100

DOCUMENT CONTROL

DAS
6 14-1-14
9-89

DC

Memo *M.L.*

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-013CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
28
9-89

14-01-9

DAS
91
9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
6 14-1-14
9-89

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Item ID: D412-698-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cabin Door Handle -Aluminum Door

Start Date: 12/17/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampDAS
6
9-89

130

0.00

130

Packaging

Packaging

Memo

PC

0.00

Packaging

Identify and pack for shipping as per PPP D412-698-
013 Location: 031

(12)

14-1-14

140

0.00

140

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

14-01-14

14-01-14

Picklist Print

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Work Order ID: 110017

Parent Item: D412-698-013

Start Date: 12/17/13

Required Date: 12/17/13

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: C Removed Manufacturing 05-11-06 JLM
IPP Rev:D change to rev D ECN 1104 08-01-28 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3203-1 Handle		Manufactured	No				Each	24.0000	4	4		DAS 14-01-10 28 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST240				24		B110090			
				108749				10					DAS
				109418				10					31 9-89
				89124				4					
D3220-041 DAS 6 9-89 Doubler Assembly		Manufactured	No				Each	6.0000		1		DAS 28 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST177				6					
				100593				6		IX			DAS 31 9-89
D3220-042 DAS 6 9-89 Doubler Assembly		Manufactured	No				Each	7.0000		1		DAS 28 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST177				7		100594			
				100594				7		100593			DAS 31 9-89
D3220-3 DAS 6 9-89 Doubler		Manufactured	No				Each	15.0000	2	2		DAS 28 9-89	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST180a				15					
				108713				6					DAS 31 9-89
				97895				9		2X			

Picklist Print

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Work Order ID: 110017

Parent Item: D412-698-013

Parent Item Name: Cabin Door Handle -Aluminum Door

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Locknut

Purchased

No

Each

4,214.0000

8

DAS
28
9-89

14-01-10

Location

Loc Qty

Loc Code

FP001

38

122452

38

GA

30

m126333

30

ST314

9

m125708

9

st507

33

m126073

33

ST509

2008

m126275

114

m127255

1894

ST510a

85

m126333

85

ST518

2011

124231

154

m127376

1857

8x

Purchased

No

Each

107.0000

16

DAS
28
9-89

Location

Loc Qty

Loc Code

ST303

107

122441

1

125578

106

16x

Purchased

No

Each

174.0000

8

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

171

m126254

171

ST294

3

m125773

3

127832

MS24694-S98

Screw

6

9-89

NAS1149D0416J

WASHER

DAS

6

9-89

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Shop Packet Print

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6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

Qty -011	Qty -012	Qty -013	Qty -017	Qty -019	Qty -021	Part Number	Description
X						D412-698-011	CABIN DOOR ROLLER KIT, LH
	X					D412-698-012	CABIN DOOR ROLLER KIT, RH
		X				D412-698-013	DOOR HANDLE KIT
			X			D412-698-017	REPLACEMENT DOOR TRACK KIT
				X		D412-698-019	BEARING OVERHAUL KIT
					X	D412-698-021	REPLACEMENT SHIM KIT
3	3					D3121-141	BRACKET ASSEMBLY
1						D3121-143	BRACKET ASSEMBLY
	1					D3121-144	BRACKET ASSEMBLY
1	1					D3137-043	BRACKET ASSEMBLY
1						D3183-043	BRACKET ASSEMBLY
	1					D3183-044	BRACKET ASSEMBLY
9	9		9			D3199-1	BRACKET
1	1		1			D3202-1	COVER
						D3203-1	HANDLE
						D3220-041	DOUBLER
						D3220-042	DOUBLER
						D3220-3	DOUBLER
				7		D3121-21	BOLT
				5		D3121-241	BEARING ASSEMBLY
				1		D3137-3	GUIDE
				1		D3137-5	WASHER
				2		D3183-045	BEARING ASSEMBLY
					3	D3238-1	SHIM
					1	D3238-3	SHIM
					2	D3238-5	SHIM
					6	D3238-11	SHIM
					2	D3238-13	SHIM
					4	D3238-15	SHIM
						AN960JD416L	WASHER
						MS21042L4	NUT (OR MS21042-4)
						MS24694-S98	SCREW
				1		MS24694-S101	SCREW

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Item ID: D412-698-013 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cabin Door Handle -Aluminum Door
 Start Date: 12/17/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 12/17/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: 12-12-17 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-698	Rev E								
100		0.00							
100	DOCUMENT CONTROL								
DC	Memo <u>M.L.D.</u>	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-698-013CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MLJ 14-01-10

1X DAS 28 14-01-9
9-89